



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Split

D3438-042
Job Sheet 175727-A



Part No: D3438-042

Job Qty: 1 ea

Part Name: Weldment Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/18/18

Job Tracking No:

Due Date: 4/13/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A IPP A 05.05.18 New Issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
180	Powdercoat	1 pcs		4/12/18	0.00	0.14	Powdercoat1		
190	HandFinish	1 pcs		4/13/18	0.00	0.49	HandFinish3		<i>3-8 15-04-18 18</i>
200	QC	1 pcs		4/13/18	0.00	0.00	QC3		<i>38</i>
210	Packaging	1 pcs		4/13/18	0.00	0.00	Packaging3-1		<i>11-10-18</i>
220	QC21-SA	1 Ea		4/13/18	0.00	0.00	QC21		<i>21</i> JUL 10 2018

Part Op 180 - 1-Touch up alodine

Descriptions: 190 - Wing Walk as per Dwg 3438 and QSI 005 4.4 Mask off 0.5 each side of D2561 lugs

M138761

9002

Job BOM

Job BOM records could not be found.

Job Allocations

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

Plex 4/18/18 8:16 AM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Suspect ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Skid-tube</td><td style="width:5%;">☐</td> <td style="width:15%;">Cross tube</td><td style="width:5%;">☐</td> <td style="width:15%;">Water Jet</td><td style="width:5%;">☐</td> <td style="width:15%;">Engineering</td><td style="width:5%;">☐</td> </tr> <tr> <td>Machining</td><td>☐</td> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Forming</td><td>☐</td> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td></td><td>☐</td> <td>Composite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td></td> </tr> </table>				Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Forming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐		☐	Composite	☐	Supplier	☐																																																								
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Date : _____		Step #: _____		MRB (QSI042) Approval Completed By _____ and / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																																																									
Description Work Order Deviation Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaero.com Container No: S062209 Part: D3438-042 Job No: 175727-A Serial No/Batch: S059714 Revision: _____ Inspector: _____ Date: 04/18/18																																																																																													
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>		Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	<table style="width:100%; border-collapse: collapse;"> <tr><td>☐</td><td>Pressure/Force</td></tr> <tr><td>☐</td><td>Bending</td></tr> <tr><td>☐</td><td>Centre Not Concentric</td></tr> <tr><td>☐</td><td>Cracks</td></tr> <tr><td>☐</td><td>Crimp/Kink/Ripple/Wave</td></tr> <tr><td>☐</td><td>Cuffs</td></tr> <tr><td>☐</td><td>Crushing</td></tr> <tr><td>☐</td><td>Heat Treat</td></tr> <tr><td>☐</td><td>Wave/Twist in Tube</td></tr> <tr><td>☐</td><td>Marks/Chatter</td></tr> </table>		☐	Pressure/Force	☐	Bending	☐	Centre Not Concentric	☐	Cracks	☐	Crimp/Kink/Ripple/Wave	☐	Cuffs	☐	Crushing	☐	Heat Treat	☐	Wave/Twist in Tube	☐	Marks/Chatter	<table style="width:100%; border-collapse: collapse;"> <tr><td>☐</td><td>Positioned Wrong</td></tr> <tr><td>☐</td><td>Outside Dimensions</td></tr> <tr><td>☐</td><td>Over/Under tolerance</td></tr> <tr><td>☐</td><td>Part Incorrect</td></tr> <tr><td>☐</td><td>Part Lost/Missing</td></tr> <tr><td>☐</td><td>Part Moved</td></tr> <tr><td>☐</td><td>Drawing</td></tr> <tr><td>☐</td><td>Finish</td></tr> <tr><td>☐</td><td>Misread</td></tr> <tr><td>☐</td><td>Turning Sequence</td></tr> </table>		☐	Positioned Wrong	☐	Outside Dimensions	☐	Over/Under tolerance	☐	Part Incorrect	☐	Part Lost/Missing	☐	Part Moved	☐	Drawing	☐	Finish	☐	Misread	☐	Turning Sequence
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Job Sheet 175727



Part No: D3438-042

Job Qty: 2 ea

Part Name: Weldment Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/10/18

Job Tracking No:

Due Date: 4/13/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A IPP A 05.05.18 New Issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		4/12/18	0.00	0.00	Start Up Large Fab-4		DO 2018-04-10
100	Large Fab	2 pcs		4/12/18	0.00	2.56	Large Fab 2		SL
110	QC	2 pcs		4/12/18	0.00	0.00	QC9		MS 2018-04-13
120	QC	2 pcs		4/12/18	0.00	0.00	QC5		MS 2018-04-13
130	HandFinish	2 pcs		4/12/18	0.00	0.97	HandFinish1		SA 18-04-16
140	QC	2 pcs		4/12/18	0.00	0.00	QC3		CPC
150	Large Fab	2 pcs		4/12/18	0.00	2.56	Large Fab 2		SL
160	QC	2 pcs		4/12/18	0.00	0.00	QC10		10-01-17
170	QC	2 pcs		4/12/18	0.00	0.00	QC5		10-04-17
175	HandFinish	2 pcs		4/12/18	0.00	0.20	HandFinish6		SA 18-04-17
180	Powdercoat	2 pcs		4/12/18	0.00	0.28	Powdercoat1		BP 18-4-17
190	HandFinish	2 pcs		4/13/18	0.00	0.97	HandFinish3		BEB
200	QC	2 pcs		4/13/18	0.00	0.00	QC3		
210	Packaging	2 pcs		4/13/18	0.00	0.00	Packaging3-1		
220	QC21-SA	2 Ea		4/13/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut D2244 to 79.63" at 34° as per Dwg D3438 3-Weld one cap, LUG PLATES & MOUNTING ANGLE as per Dwg
Descriptions: D3438 using DT8343 4-Grind

150 - Weld last cap per dwg D3438 & grind flush

175 - Touch up alodine

180 - 1-Touch up alodine

190 - Wing Walk as per Dwg 3438 and QSI 005 4.4 Mask off 0.5 each side of D2561 lugs

M.B8760 START: 9:15 O.V.T. 300° FINISH 9:45

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	2 Ea (1 ea)	90-Start up Operation	5014552
D2561	Lug	4 Ea (2 ea)	90-Start up Operation	5041761
D2673-34	End Plate	4 Ea (2 ea)	90-Start up Operation	5042088
D2564	Mounting Angle	4 Ea (2 ea)	90-Start up Operation	5052121

Wing walk. M138761

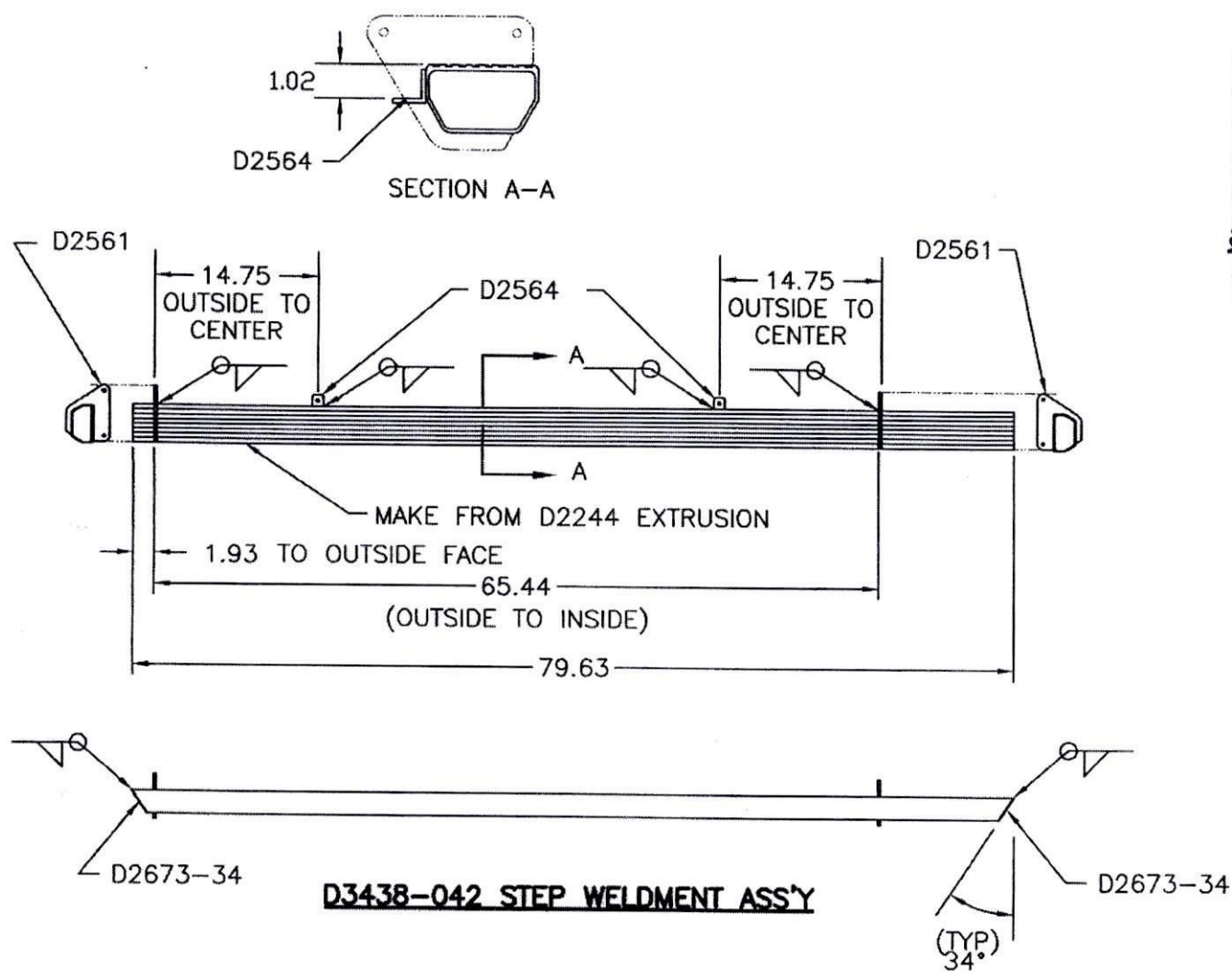
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	2	154	0
	D2561	4	4	0
	D2564	4	15	0
	D2673-34	4	25	0
Part Specifications				
Specifications could not be found.				

Plex 4/10/18 1:04 PM dart.lacelle.linda

DART

RELEASED

05.05.22

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) TOLERANCES ARE PER DART QSI 018
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) FINISH: ACID ETCH & ALODINE PER QSI 005 4.1, POWDER COAT WHITE PER QSI 005 4.3.5.1 WING WALK TOP PER QSI 005 4.4, MASK OFF 0.5 EACH SIDE OF D2561 LUGS

DESIGN	RF	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.05.09	DRAWING NO.	D3438	REV. A
		TITLE	STEP WELDMENT ASSEMBLY	SHEET 1 OF 1
A		05.05.09	NEW ISSUE	SCALE 1:1